

Work Order ID 50841

July 31, 2009 8:34:15 AM

Page 1

Item ID: D205-634-041

Accept

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 08/13/2009 Start Qty: 1.00

Required Date: 09/04/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

09-07-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 0 BE 09/07/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

1 0 26 09/08/05

27 110 C 07/06/05

80

9

W/O:		WORK ORDER CHANGES					
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Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R 110295 Aluminum Rod

m110295

BE 09/08/05

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R 110295 Aluminum Rod

m110295

BE 09/08/05

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 09/08/05

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

=> 8 08/08/05

(2)

f

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

=> 8 08/08/05

(2)

f

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

=> 09-08-06

(1)

ll

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 5

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1112260

Memo

0.00

Powder Coating

START TIME:

8:30AM

OVEN TEMPERATURE:

375°F

FINISH TIME:

9:00AM

=>

09-08-06

(X)

JH.

190



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

PL 09-08-06

(B)

W/O:		WORK ORDER CHANGES					
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Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ m111557
Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ m111557
Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: m112106

X1

MD 09/08/06

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July 31, 2009 8:34:15 AM



Page 7

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Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

25 09/08/07



220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

PP

9/8/25 @ SP

51034

230

QC21- Final Inspection - Work Order Release

0.00



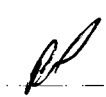
QC

Memo

0.00

Quality Control

09/08/25



09-8-25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

July 31, 2009 8:34:14 AM

Page 1/9

Work Order ID: 50841



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	7.0000	1.0000			
205 Skidtube bent detail												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

48616

1

50760

6

850758 *1 BE 09/08/05

D2576-3RevG

Manufactured No

140

Each

165.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

165

43504

62

46661

103

1 BE 09/08/05

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			
Crossbolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	412	
43988	4	
46434	4	
46956	12	
47797	338	
48272	54	

20 BE 09/08/05

D2855RevA

Manufactured No

200

Each

66.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6	52	
50513	52	

Main Warehouse

ST	14	
10360	2	
35663	7	
41340	1	
42343	3	
42806	2	
50513	-1	

X1 MD 09/08/06

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AN3-5A		Purchased	No			200	Each	2,560.000	2.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2560

100188

246

105057

2246

15205

68

X2 MD 09/08/06

AN960JD10L

Purchased

No

200

Each

6,911.000

2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6911

101291

16

104885

153

105793

236

109632

1506

110985

5000

X2 MD 09/08/06

Dart Aerospace Ltd

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ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			

Insert

*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	110511	
ST	3706	
105855	16	
108606	52	
111529	1638	
111779	2000	

x50 MD 09/08/06

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2071	
112082	121	
112314	1950	

x50 MD 09/08/06

July 31, 2009 8:34:14 AM

Shop Packet Print

Page 4

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

200

Each

4,591.000

50.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4491

112116

4491

D3566-13RevC

Manufactured

No

200

Each

47.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

45717

1

46889

5

47435

7

48166

18

50265

16

X50 MD 09/08/06

X1 MD 09/08/06

Dart Aerospace Ltd

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3566-5RevC

Manufactured

No

200

Each

22.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

36113

1

46186

1

47318

1

48167

19

D3566-1RevC

Manufactured

No

200

Each

34.0000

2.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

46349

1

47434

2

48165

8

48557

11

50278

12

X1

MD 09/08/06

X2

MD 09/08/06

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D3564-11RevD		Manufactured	No			200	Each	30.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 30

45823 1

47432 7

48553 12

50112 10

XI MD 09/08/06

D3564-13RevD

Manufactured No

200

Each

55.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 35

48554 13

50270 22

XI MD 09/08/06

Main Warehouse

ST 20

45409 3

46495 10

47867 7

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 31, 2009 8:34:14 AM

Work Order ID: 50841



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	17.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 17

44659 1

45825 1

47316 4

48556 11

D3564-5RevD

Manufactured No

200

Each

22.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 2

34806 2

Main Warehouse

FP19 12

48555 12

Main Warehouse

ST 8

45824 1

47433 1

48164 6

X1 MD 09/08/06

X1 MD 09/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 31, 2009 8:34:14 AM

Work Order ID: 50841

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC  O-Ring, 205 Skidtube		Manufactured	No			200	Each	894.0000	16.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

894

27168

44

29908

850

D2594-1RevC

Manufactured

No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

700

42221

16

42807

92

43884

87

46435

3

47251

502

~~X16~~ MD 09/08/06

~~X16~~ MD 09/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

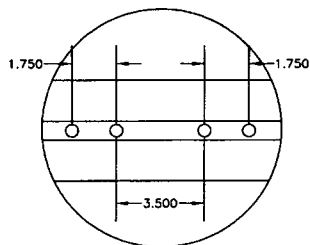
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

#50841
09-07-99

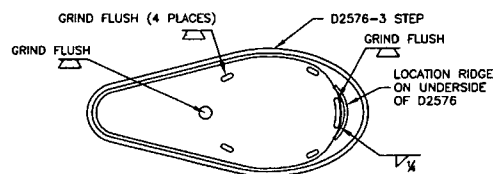
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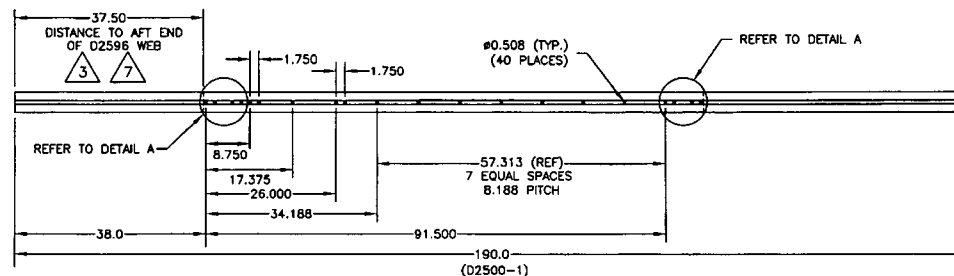
DETAIL A
SCALE 5:24



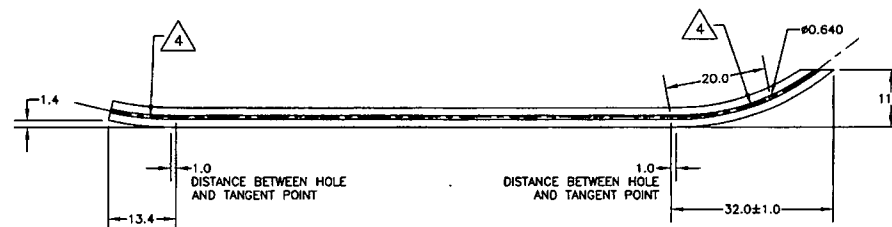
DETAIL B
SCALE 5:24



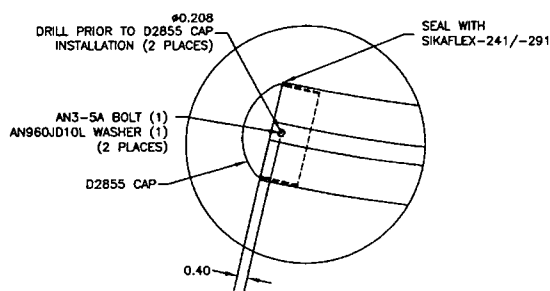
D2580-1 DRILLING DETAIL



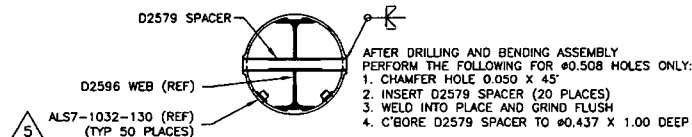
D2580-1 BENDING AND CUTTING DETAIL



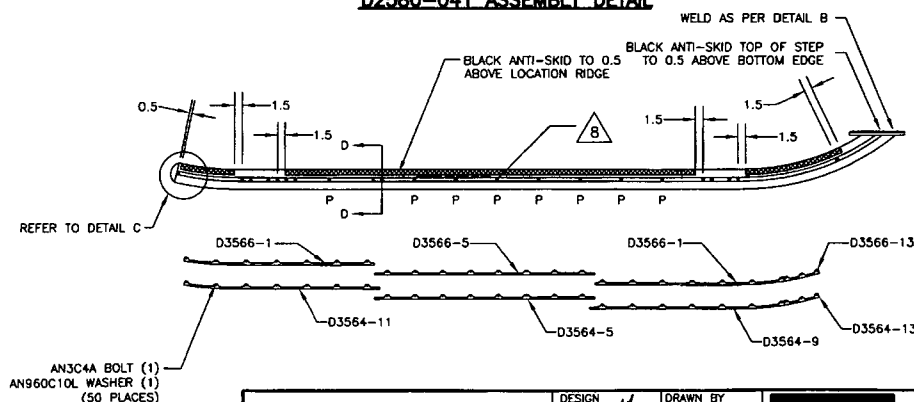
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Diagram illustrating the rear view of the engine cover assembly, showing the installation of the D2855 cap. The diagram includes the following components and labels:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the locations where the cap is secured.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the cap.
- AN3-5A BOLT (1)**: Points to the bolt used for securing the cap.
- AN960JD10L WASHER (1) (2 PLACES)**: Points to the washer used for securing the cap.
- D2855 CAP**: Points to the cap being installed.
- SEE NOTE ii)**: Points to the note indicating the cap is to be installed as shown in the next page.
- 0.40**: Dimension indicating the distance from the center of the bolt to the edge of the cap.

Diagram of a cross-section of a mechanical part. The part is circular with a central vertical slot. Labels point to various features:

- D2579 SPACER (points to the top horizontal bar)
- D2596 WEB (REF) (points to the central vertical slot)
- ALS7-1032-130 (REF) (TYP 50 PLACES) (points to the bottom horizontal bar)

Assembly instructions:

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE $0.050 \times 45^\circ$
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750
17.375
26.000
34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0 91.500

190.0
(D2500-1)

Technical drawing of a propeller hub cross-section. The drawing shows a horizontal hub with a central hole and a curved leading edge. Key dimensions and callouts include:

- Overall length: 51.340
- Distance from left face to center of hole: 5.338 (REF)
- Distance from center of hole to start of curve: 3.630 (REF)
- Radius of curve: $R = 39.580$
- Distance from start of curve to end of hub: 5.915
- Number of blades: $\phi 0.508$ (8 PLACES)
- Blade thickness at root: 20.0
- Blade root diameter: $\phi 0.640$
- Hub thickness at left face: 1.4
- Hub thickness at right face: 1.1
- Distance between hole and tangent point (left): 1.0
- Distance between hole and tangent point (right): 1.0
- Hub thickness at tangent point (left): 13.4
- Hub thickness at tangent point (right): 32.0 ± 1.0
- Callout 4: Points to the hub thickness at the left face and the distance between the hole and the tangent point (left).

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

H

NO C'BORE NO PLUG

REFER TO DETAIL G

NO C'BORE NO PLUG

P

H

8

1.5

1.5

1.5

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

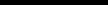
D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY	
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		DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

NO. 205

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: D205 634 041 50835
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P.C. M.H. Date of Test Coupon 09.07.30

Welder Barday Elliott Date of Test Coupon 09.07.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld